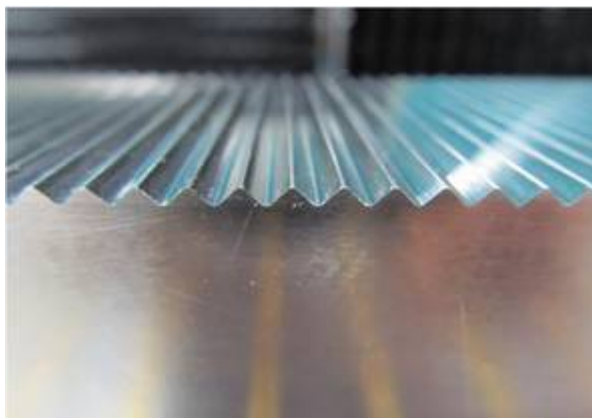
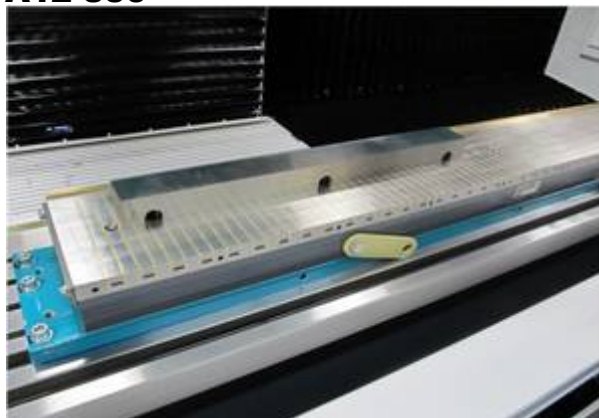










## Rolling Rack

### A12-830



- Pitch is very well
- Tooth ground and tooth width needs more experienced data
- If the basic form of the tools are not exactly straight, the measurement results from a measuring machine are very difficult to interpret, or not useable.

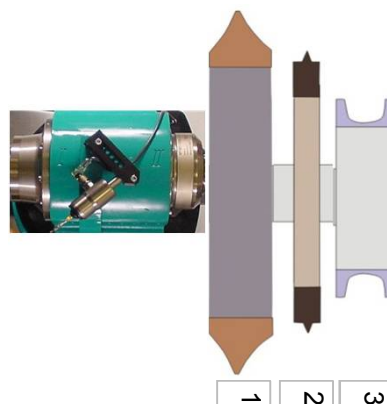
### 1. Cycletime for Resharpener

Workpiece:	Width 60mm; height 45mm length 609mm							
Material HSS								
Operations								
Feed [mm/Min]	2000	80	250	250	80	1000	80	2000
Power [kW]		1	5	1	1	1	1	1
Cutting speed [m/s]		10	30	30	15	35	15	35
Used wheels		1	1	1	1	2	3	3
Grinding time [min]	0	45	125	145	15	25	5	40
Total cycle time	6h 40min							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	DXF Ø200 B126
2	DXF Ø200 C280
3	DXF Ø200 C280



### 3. Machine and Software Requirements

Machines:	6 axes CNC grinders : CORVUS BBA	Coolant:	Synthetic Oil, pressure 6 bar
Control:	Fanuc 31A5	Software:	Quinto 5.4.6
Accessories:			

Responsible engineer: LIM, 14.05.2014

[www.schneeberger.ch](http://www.schneeberger.ch)

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